



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP-1404-1-3
Job Sheet 194212



Part No: RBBP-1404-1-3

Job Qty: 10 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBBP-1404-1 Rev.2 IPP Rev. A 18.11.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Large Fab - Welded Assy-1	10 pcs	5/31/19		0.00	2.50	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
110	QC 9	10 pcs	5/31/19		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	
							QC 9 - 9	
120	QC 5	10 pcs	5/31/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S228667



Part: RBBP-1404-1-3

Job No: 194212

Serial No/Batch: S228667

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/31/19

Plex 4/29/19 8:26 AM Dart.lajeunesse.marie

				QC 5 - 30		
				QC 5 - 40		
130	Outsource - 13 - Zinc Plating	10 pcs	5/31/19		GRO002-VC 5	2019-11-04
140	Packaging 2-1 - Receive - B4B	10 pcs	5/31/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	NOV 08 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150	QC 6	10 pcs	5/31/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	NOV 08 2018
					QC 6 - 61	9-89
					QC 6 - 40	
160	Packaging 3-1 - Stock - B4B	10 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

170 QC 21 - SA	10 pcs	5/31/19	0.00 0.00	Packaging 3 - 17 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Weld as per DWG
 Descriptions: 130 - -Issue P/O : 44995 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of
 Conformity is required
 140 - Certificate of Conformity is required

DAS 21 NOV 15 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBBP-1404-1-5	Bolt, Modified	10 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5190979</u>
RBBP-1404-1-7	Eye	10 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5197650</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RBBP-1404-1-5	10	100	0
	RBBP-1404-1-7	10	112	0

Part Specifications

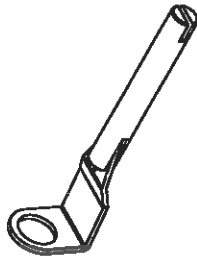
Specifications could not be found.

Plex 4/29/19 8:26 AM Dart.lajeunesse.marie

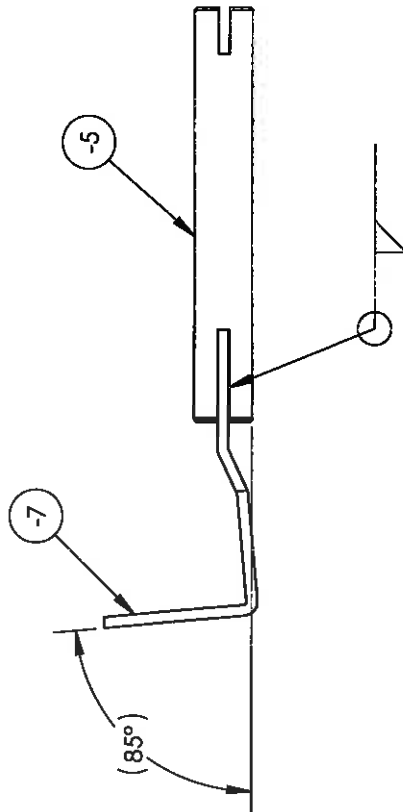
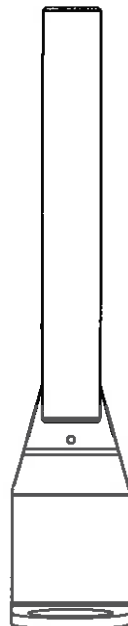
This drawing, specifications, and concepts contained here in are the sole property of Dert Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dert Aerospace Eugene, OR.

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0025	-3 CHD FINISH WAS CAD PLATE YELLOW IS ZINC PLATE.	2/8/2016	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
OUT TO AMENDMENT
WITHOUT NOTICE
BY ORDER
19422 MJS
19422A



(3)

WELDMENT



K-FLEX DRIVE SHAFT TOOL

TITLE	DWG NO.	REV
K-FLEX DRIVE SHAFT TOOL	RBBP-1404-1-3	2
MATL	UNLESS OTHERWISE SPECIFIED	
FINISH	DIMENSIONS ARE IN INCHES	
FRONT	.XXX ± .010 FRACTIONS ± 1/8	
ZINC PLATE	.XX ± .03 ANGLES ± 1°	
SPEC	ASTM B633 TYPE I SC 2	
DRAWN BY:	CLOUGH	
CHECKED:	DUERFELDT	
OPPS APPR:	ANDERSON	
QA APPR:	LINDSAY	
APPROVED:	GILBERT	
SCALE	1:1	
DATE	1/14/2011	
SHEET	3 OF 5	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____			
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

Tel (613) 632-5200

PURCHASE ORDER
POHB044995



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-1666
Fax: 514-335-3808

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:	POHB044995
PO Date:	11/4/19
Due Date:	11/12/19
Purchase Order	
Revision:	
Revision Date:	
Ship-To Contact:	Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

2019-11-05

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200568	8NR-49	8NR-49 Rev 2	Stiffener 2 Hole -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed X10	-	11/12/19	10 pcs	0 pcs	10 pcs	\$5.25/pcs	\$52.50
NOV 08 2019												
2	199669	RBE105-14102W2-3	RBE105-4102W2 Rev 1	Connecting Pin -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed X6	-	11/12/19	6 pcs	0 pcs	6 pcs	\$3.50/pcs	\$21.00
NOV 07 2019												
OP												



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044995



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	194212	RBBP-1404-13	RBBP-1404-1 Rev 2	Weldment -Issue P/O Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/12/19	10 pcs	0 pcs	10 pcs	\$9.00/pcs	\$90.00
					X10					NOV 08 2019		
4	200570	RB6798860-4	RB6798860 Rev 2	Bridge -Issue P/O; Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/12/19	7 pcs	0 pcs	7 pcs	\$5.25/pcs	\$36.75
					X7					NOV 07 2019		
Grand Total:												\$200.25

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/5/19 1:04 PM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(023818-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**023818 - 2**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
06-Nov-2019	Jigar Patel		POHB044995					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	8NR-49 Rev.2	8NR-49 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2,SC - 2 0.0003 "	ZINC CH	10	10	0	0	0
3	RBBP-1404-1-3 Rev.	RBBP-1404-1 2 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1,SC - 2 0.0003 "	ZINC CH	10	10	0	0	0

RECEIVED
NOV 08 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.